

# Work Order ID 56296

February 17, 2010 2:26:51 PM

Page 1

Item ID: D3238-21

Accept

Setup Start

Revision ID:

Stop

Item Name: Plate

Start Date: 2/17/10 Start Qty: 10.00

Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3238

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3238 [1]Dwg Rev: 03038-21 [1]Prog Rev: C [1]2-  
Debur if necessary \*\*\*\*\*USE D3238 BLANK CUTTING FILE\*\*\*\*\*

2024. 086

SP10/02/24 (12)

MAT NOT PULLED

B 10-2-23

110

0.00



Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

Machine Serration on Sheet using DT8934 PLATE

SP10/02/23

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 10-2-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56296

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Page 2

Item ID: D3238-21

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Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 2/17/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

0.00

1-Cut as per Dwg D3238 ☐ Dwg Rev: ☐ Prog Rev: ☐ 2  
Deburr if necessary ☐ \*\*\*Use cutting file D3238-21-23-25\*\*\*\*\*

n/a S

Pho →

140

0.00



QC

Quality Control

QC2- Inspect parts off machine FA/FAIB

Memo

0.00

150

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

S 10/62/24

xll (H)

Pho →

# Dart Aerospace Ltd

W/O: 56296		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/02/23	#130	Perm. Change Remove step #130 + 140. each part must be cut on a <del>separate</del> separate w/o		10/03/04		10/02-24	10/02/23
	#140						

Part No: D3238-21 PAR #: \_\_\_\_\_ Fault Category: Small Part / Water Jet NCR: Yes No DQA: \_\_\_\_\_ Date: 10/03/04  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: 10/03/04

NCR: 56296		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/02/24	#130	Found Qty +1 Part with the hole location shifted to one side by 0.050". <del>It must be</del> to clamping	10/02/24	-Scrap + Destroy Qty +1 no Replace	10-2-24	10/02/24	10/02/24	10/02/24
		cutting outside profile on water jet. R.C. process						

NOTE: Date & initial all entries

# Work Order ID 56296

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Item ID: D3238-21

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 2/17/10

Start Qty: 10.00



Cust Item ID:

Required Date: 2/24/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

7m-1 w/02/25

11X

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

W 10/02/25

X 11

-7

180

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

Per 2/26 100

adjust inventory

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56296**

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Item ID: D3238-21

Accept

Setup Start

Revision ID:

Stop

Item Name: Plate

Start Date: 2/17/10 Start Qty: 10.00

Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03 *[Signature]*  
CL 03/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

February 17, 2010 2:26:55 PM

Page 1

Work Order ID: 56296



Parent Item: D3238-21



Parent Item Name: Plate

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A New Issue 07-01-26 JLM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M2024T3S.080

Purchased

No

100

sf

153.0250

0.2526

3



2010-2-23

2024-T3 .080 sheet

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

153.02505

104921

3

105411

17

107460

4.36

110908

29.52205

112331

24.643

113796

65

15628

6

17695

1.5

18481

2

109242

109242

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 56296
<b>Description:</b> Plate		<b>Part Number:</b> D3238-21
<b>Inspection Dwg:</b> D3238	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.203	+0.005/-0.001	.207	✓			
0.40	+/-0.030	.399	✓			
0.33	+/-0.030	.33	✓			
1.96	+/-0.030	1.964	✓			
1.300	+/-0.010	1.304	✓			
1.75	+/-0.030	1.749	✓			
0.950	+/-0.010	.952	✓			
0.80	+/-0.030	.80	✓			
0.65	+/-0.030	.651	✓			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b> N/A
<b>Date:</b> 10-5-23	<b>Date:</b> 10/02/24	<b>Date:</b> N/A

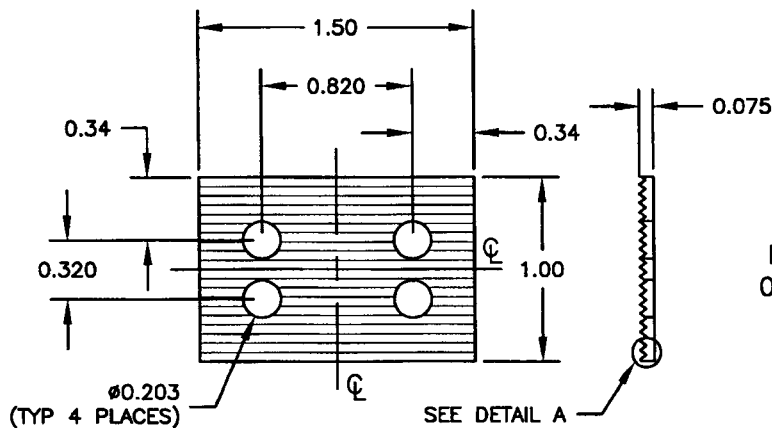
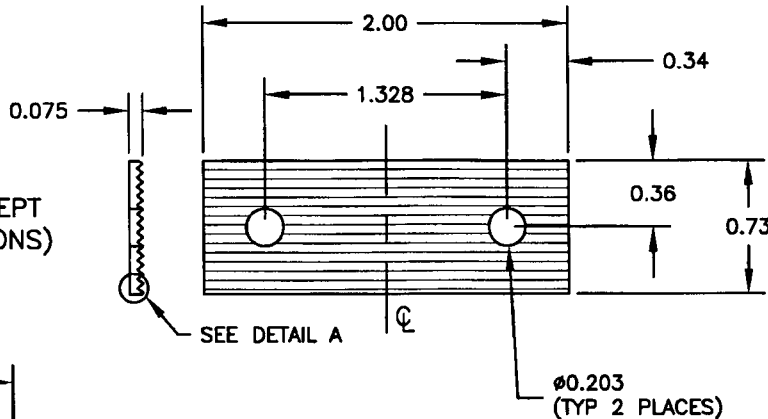
Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	DD

**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

**RELEASED**

07.02.20 #

**D3238-1 PLATE (SHOWN)**D3238-11 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)**D3238-3 PLATE (SHOWN)**D3238-13 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36296  
B/P 10-217**NOTES:**

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:  
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S)  
-11/-13/-15/-31/-33/-35 PLATE:  
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR  
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)  
OR  
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR  
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT  $\phi$

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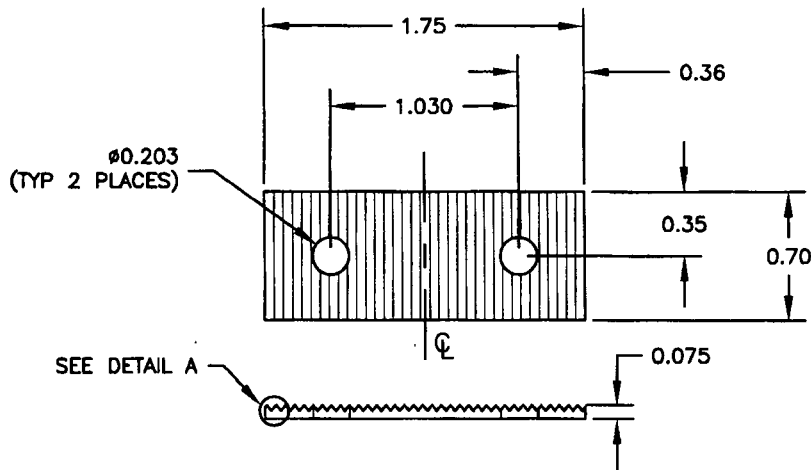
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**DART**

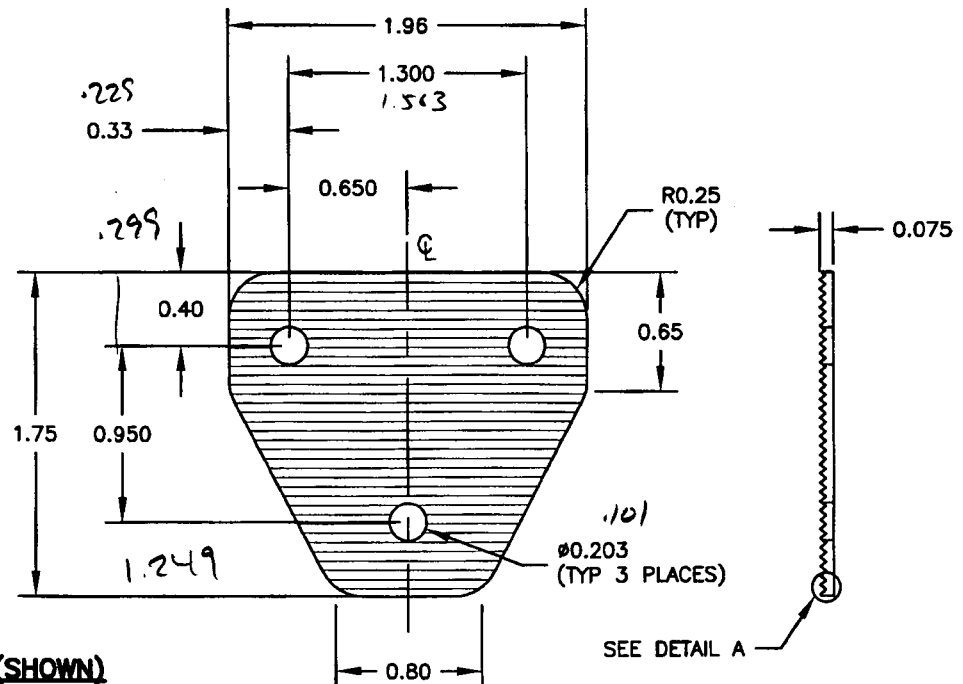
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CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1

**RELEASED**

07.02.20



**D3238-5 PLATE (SHOWN)**  
D3238-15 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**D3238-21 PLATE (SHOWN)**  
D3238-31 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

SEE DETAIL A

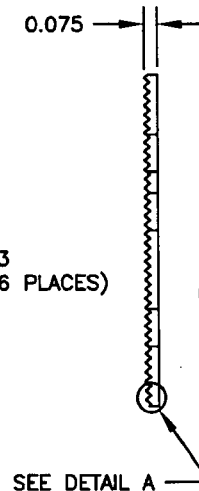
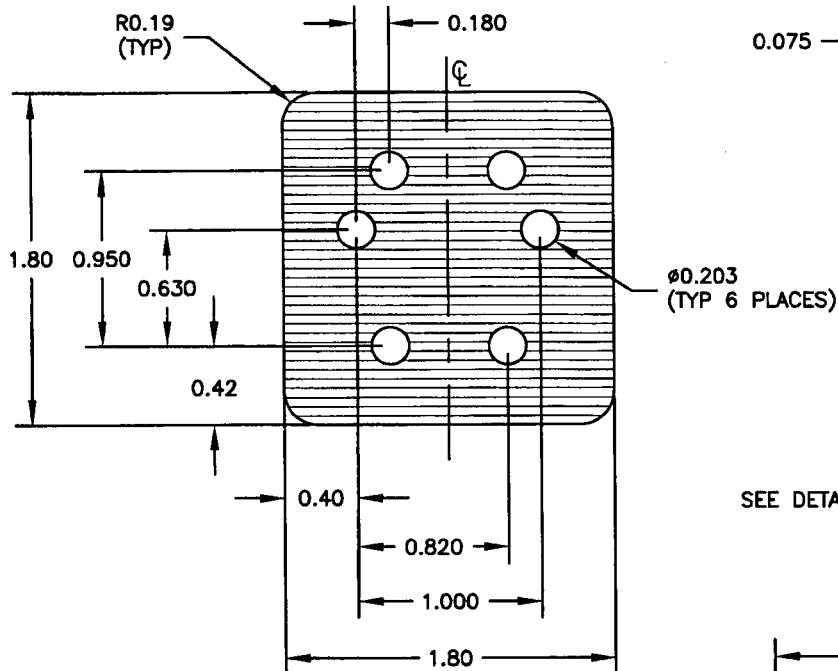
w/0 56296

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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1

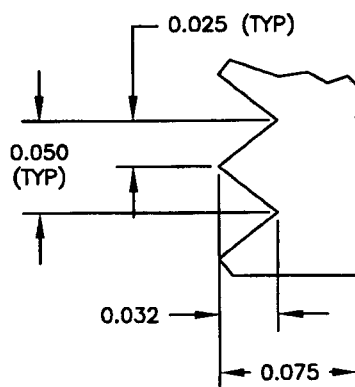


RELEASED

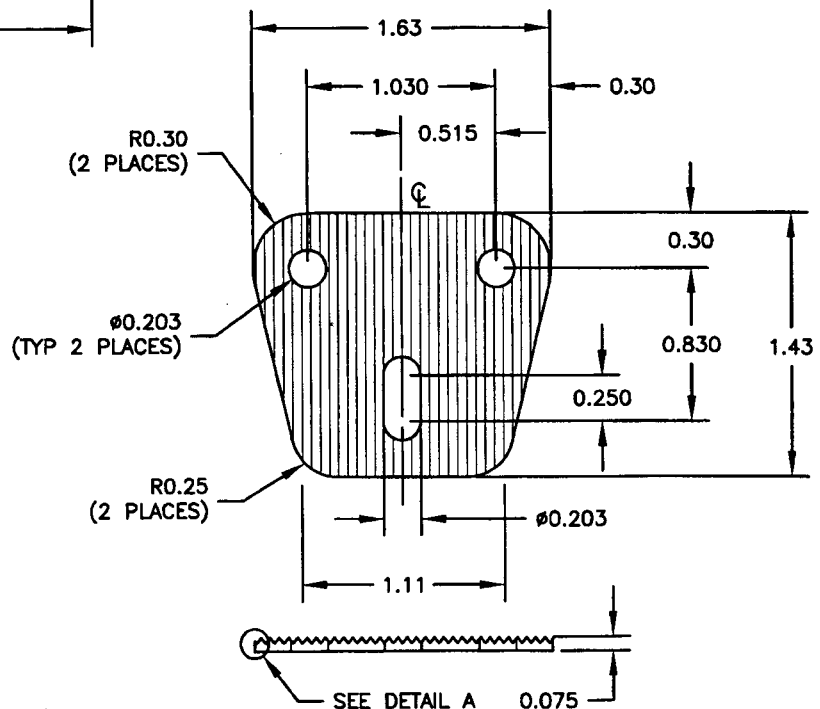
07.02.20

**D3238-23 PLATE (SHOWN)**  
D3238-33 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

W/056296



**DETAIL A**  
RIDGE DETAIL (VIEW MAY BE ROTATED)  
SCALE 10:1



**D3238-25 PLATE (SHOWN)**  
D3238-35 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

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